

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020033**Date Inspected:** 17-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 9BE.

FCAW welding of weld joint SSD27-PP74-139, 140; located on assembly, Bay 14, 9BE. Welder is identified as 044795; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2132.

Assembly, Bay 14, 12BW, FL3 to Side Panel.

SMAW welding of weld joint SEG3005A-004; located on assembly, Bay 14, 12BW. Welder is identified as 066361, 037840; ZPMC Quality Control Inspector (QC) is identified as Xu Tao. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4B-FCM-1.

Assembly, Bay 14, 11DW, Corner Assembly, Side plate to Deck plate.

FCAW welding of weld joint SEG071A-032; located on assembly, Bay 14, 11DW. Welder is identified as 048696, 058245; ZPMC Quality Control Inspector (QC) is identified as Xu Tao. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

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Assembly, Bay 14, 12BW, Corner Assembly, Deck panel stiffeners.

FCAW Repair welding of weld joint CA3008C-011, 012; located on assembly, Bay 14, 12BW. Welder is identified as 058245; ZPMC Quality Control Inspector (QC) is identified as Xu Tao. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4133.

Assembly, Bay 14, 11DE, X35 Stiffener.

SMAW welding of weld joint SEG072D-015, 018, 070, 073; located on assembly, Bay 14, 11DE. Welder is identified as 215553; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS:

1)WPS-B-P-2213-TC-U4B-FCM.

2) WPS-B-P-4213-TC-U4B-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
